

Date: Wednesday, 06/08/2008 9:20:01 AM
 User: Julie Lecocq

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 40998 <i>23</i>	Part Number	: D412630034
Estimate Number	: 12568	Drawing Number	: IIN D412-630
P.O. Number	:	Project Number	: N/A
This Issue	: 06/08/2008 S.O. No. :	Drawing Revision	: L
Prsht Rev.	: NC	Material	:
First Issue	: 06/08/2008 Type : LARGE FAB ASSY	Due Date	: 28/08/2008
Previous Run	: 40269	Qty:	<i>5</i> Um: Each
Written By	:		
Checked & Approved By	: <i>JLD 08-8-06</i>		
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

*JLD 08.8.06*

Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<i>40274</i>

AS 08/08/07

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	<i>34017x2</i>

AS 08/08/07

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	<i>35827</i>

AS 08/08/07

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Prop

Batch:

35751

AS 08/08/07 (X5)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

34020

AS 08/08/07 (X5)

7.0

D3562042

Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-042

Step Weldment RH

B41039
B41246

B08/09/11 (2)
B08/09/02 (2)

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

33578 x14

AS 08/08/07 (X5)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

101189

AS 08/08/07 (X5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	AN8C16	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	102066

JS 05/08/07 (X5)

11.0	AN310C8	Nut
------	---------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	M106431

JS 08/08/07 (X5)

12.0	MS24665302	Cotter Pin
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	M106763

JS 08/08/07 (X5)

13.0	NAS1515H3	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	M10761

JS 08/08/07 (X5)

14.0	NAS1515H5L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	M108964

M108964 (3x)

JS 08/08/07 (X5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M106575

JS 08/08/07 (X5)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108672

JS 08/08/07 (X5)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

JS 08/08/07 (X5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH:

M104251

JS 08/09/11 (2)

JS 08/09/02 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/04/11 (2)

JS 08/09/02 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

35630

B35630 x 6 AS 08/09/11 (B)

AS 08/09/02 (X2)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

34019

B340534 x 2 AS 08/09/11 (B3)

AS 08/09/02 (X2)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B41029 x 3 AS 08/09/11 (X3)

AS 08/09/02 (X2)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

B34025 x 6 AS 08/09/11 (X3)

AS 08/09/02 (X2)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M107242

M107242 x 3 AS 08/09/11 (X3)

AS 08/09/02 (X2)

Process Sheet

split

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

M101189 x3

AS 08/09/11 (x3)

M101189

AS 08/09/02 (x2)

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

M107082

M103248

M107082 x6

AS 08/09/11 (x3)

AS 08/09/02 (x2)

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C7A	Eyebolt

Batch

M100446 x3

AS 08/09/11 (x3)

M100446

AS 08/09/02 (x2)

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

M105125 x6

AS 08/09/11 (x3)

M105125

AS 08/09/02 (x2)

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

M108558 x21

AS 08/09/11 (x3)

M108558

AS 08/09/02 (x2)

Process Sheet

Picked for 3 more

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M108334 x21

JS 08/09/11 (x3)

M108334

JS 08/09/02 (x2)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M108672 x12

JS 08/09/11 (x3)

M108672

JS 08/09/02 (x2)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

Split = 3

M108583 x9

JS 08/09/11 (x3)

M108583

JS 08/09/02 (x2)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08-09-12 (x2)

Labels already on kits

08/09/12 (x2)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

Rev A

Rev A

JS

08/09/02

(x2)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15 (x3)

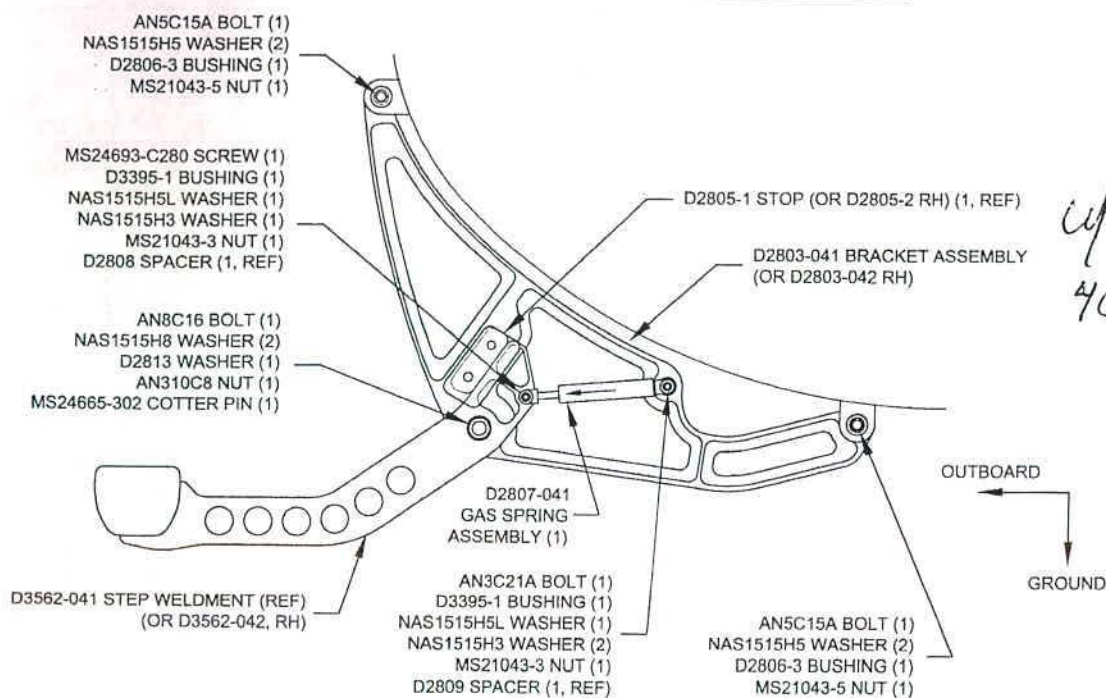
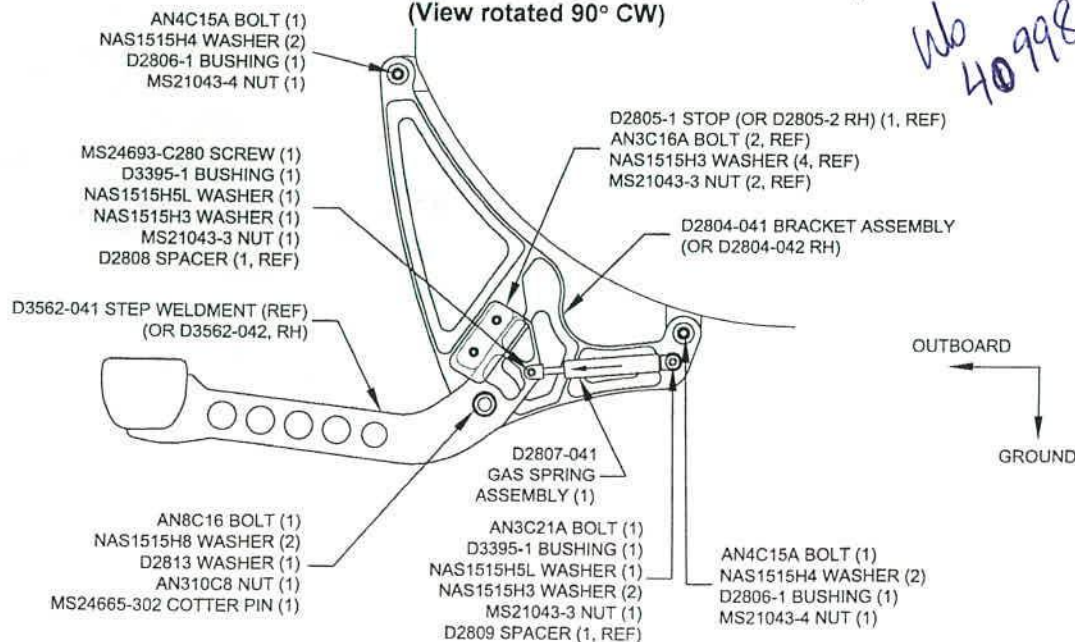
08/09/02 (x2)

Job Completion



u 08-09-02

u 08-09-12 2

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)****FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)**

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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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